

Work Order ID 82393

March-30-12 7:48:02 AM

82393

Page 1

Item ID: K642-512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: saddle kit 642-512
 Start Date: 29/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/30 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	O								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-512 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 16 12/03/13
JB

2 12/08/03/13

DAS 16 12/03/13

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82393

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82393

Page 2

Item ID: K642-512

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: saddle kit 642-512

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

0.00

Packaging

Memo

Identify and pack for shipping as per PPP K642-512 Location: pk

2 12/8/13

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/08/14

12-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-30-12 7:48:06 AM

Work Order ID: 82393

82393

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00


Required Qty: 2.00

Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5C34A		Purchased	No			110	Each	68.0000	4	✓			

S
TZ
AN5C34A

**

JB 

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST339	66	
119083	11	
119530	30	
121013	25	

119530

D206-648-013


CHL7WZ

Manufactured No

S
PW
D206-648-013

110 Each 15.0000

**

83041 JB  12/08/03

Location	Loc Qty	Loc Code
FG	3	
78875	3	
FG120	12	
65455	0	
66633	0	
81332	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2932-2

Manufactured No

110

Each

14.0000



2

**

83424 JB

SP

D2932-2

Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

4

79224

4

ST428

10

75100

4

78986

6

D2933-2

Manufactured No

110

Each

15.0000



2

**

83425 JB

SP

D2933-2

Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

4

79227

4

ST428

11

74604

3

75101

4

78963

4

D2938-2

Manufactured No

110

Each

16.0000



2

**

86424 JB

12/08/03

SP

D2938-2

Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

4

79229

4

ST428A

12

75102

4

81622

8

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2939-2

Manufactured No

110 Each

16.0000

0

2

**

83418 JB

SP

D2939-2

Saddle RH Lin, 206

Location

Loc Qty

Loc Code

ST421

4

79231

4

ST428A

12

74608

3

75103

3

78955

6

AN3C41A

Purchased No

110 Each

144.0000

8

16

**

122241 JB SP 12/08/03

AN3C41A

BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

140

119673

50

120753

30

121013

50

121067

10

D2652

Manufactured No

110 Each

532.0000

16

32

**

387617 SP

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

488

73836

36

77134

375

77136

77

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W/O:		WORK ORDER CHANGES					
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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

613.0000

20

40

MS21043-3

Nut

**

121708 JB

JB

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

270

120693

270

ST301

271

118077

2

118614

219

118686

30

119758

20

D3672-7

Manufactured

No

110

Each

1,144.000

24

48

D3672-7

Phenolic Washer

**

JB

Location

Loc Qty

Loc Code

ST060

1144

73488

16

76279

628

81872

500

76279

AN5C11A

Purchased

No

110

Each

192.0000

8

16

AN5C11A

Bolt

**

JB 12/08/03

Location

Loc Qty

Loc Code

FG

4

103715

4

ST337

188

119328

38

120423

50

121009

100

121009

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C12A

Purchased

No

110

Each

76.0000

4

8

**

AN5C12A

BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

74

119328

24

120518

50

AN5C13A

Purchased

No

110

Each

225.0000

4

8

**

AN5C13A

BOLT

Location

Loc Qty

Loc Code

ST338

225

118983

25

119537

100

120562

100

AN960C516L

NAS1149C0532

Purchased

No

110

Each

0.0000

8

16

**

*AN960C516I *

WASHER

AN4C6A

Purchased

No

110

Each

294.0000

12

24

**

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

290

116704

2

120423

200

120521

88

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3672-3

Manufactured No

110 Each

602.0000

24

48

**

84361 JB

SP

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST060

602

64176

172

81870

430

Purchased No

110 Each

0.0000

24

48

**

121255 JB

SP

AN960C4161

AN960C4161

WASHER

MS21043-4

Purchased No

110 Each

1,953.000

13

26

**

122452 JB

SP

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1913

119546

370

120308

543

121162

1000

Manufactured No

110 Each

33.0000

1

2

**

86919 JB

SP

12/08/03

D3407-043

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST420

13

79232

13

ST463

20

68339

2

74519

3

78841

15

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D3456-1

Manufactured No

110 Each

150.0000

D3456-1

Washer

** 0 2 ✓

83584 JB

GP

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

143

80252

43

81876

100

D3457-1

Manufactured No

110 Each

99.0000

D3457-1

Washer

** 2 4 ✓

~~83584~~ JB

~~83584~~ JB

GP

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

89

67779

1

78801

28

81977

60

D2712

Manufactured No

110 Each

902.0000

D2712

Set Screw

** 10 20 ✓

83559 JB

GP

12/08/03.

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

700

79585

500

81871

200

ST021

152

76065

152

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

D2934

Manufactured No

110 Each

68.0000

2

4

D2934

Saddle Spacer

**

82014 JB SP

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

62

74883

8

78802

54

D2935

Manufactured No

110 Each

96.0000

2

4

D2935

Saddle Spacer

**

82013 JB

Location

Loc Qty

Loc Code

FG

6

31793

6

ST021

90

74882

6

78807

84

AN3C36A

Purchased No

110 Each

107.0000

9

18

AN3C36A

BOLT

**

122491 JB 12/08/03

Location

Loc Qty

Loc Code

FG

4

101261

4

ST353

103

116590

0

119083

2

119324

39

121013

55

121167

7

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist-Print

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C35A

Purchased No

110 Each

91.0000

3 6 ✓

AN3C35A

BOLT

JB

SP

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

87

119125

12

119449

50

121013

25

121013

AN960C10L

NAS1149C0332

Purchased No

110 Each

0.0000

24 48 ✓

AN960C10L

washer

122063 JB

SP

D3672-1

Manufactured No

110 Each

1,038.000

24 48 ✓

D3672-1

Phenolic Washer

JB

SP

Location

Loc Qty

Loc Code

FP001

34

66821

34

ST060

1004

72229

4

76277

500

80369

500

80369

D3396-3

Manufactured No

110 Each

35.0000

2 4 ✓

D3396-3

Spacer

2x 82073 JB 12/08/03
2x 85428

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

25

73349

25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C35A

Purchased

No

110

Each

51.0000

**

2

1b 8p

AN5C35A

Bolt

Location

Loc Qty

Loc Code

ST340

51

108407

1

118451

25

119749

25

118451

AN5C15A

Purchased

No

110

Each

95.0000

**

2

1b 8p

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

95

118191

3

119749

12

120422

30

120833

25

121162

25

120422

AN5C32A

Purchased

No

110

Each

115.0000

**

4

12/08/03

AN5C32A

Location

Loc Qty

Loc Code

FG

4

18918

4

ST339

111

117407

11

119035

50

120578

50

119035

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 82393

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

82393

K642-512

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

110

Each

475.0000



8 ✓

**

JP

JB

12/08/03

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG	20
101418	20
ST300	30
112314	30
ST301	425
116548	100
118159	100
119307	25
119537	200

119537

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C51CL)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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